Date:	Thursday, 6/21/2007 2:29:08 PM			
User:	Kim Johnston Pro	cess Sheet		
Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE	
Job Number	: 33055	•		
Estimate Num	F 1191			
P.O. Number	: NA		D25771	
This Issue	: 6/21/2007 S.O. No. : PLA	•	D2577 REV E N/A	
Prsht Rev. First Issue	: NC : Type : SMALL /MED FAB		E	
Previous Run	00010		MA	
Written By		Due Date :	7/10/2007 Qty:	30 Um: Each
Checked & Ap	pproved By			
Comment	: Est: E 02.09.24 Re-format; Incorpora	ited D2577-101/-11 K		
	J/RF			
	est F 06.09.11 now waterjet	EC		
Additional Pro	oduct			
Job Number:	1 (44/4 1/1/14 1/14 1/1/1		****	
Seq. #:	Machine Or Operation:	Description :		
1.0	M1010S16GA 1010	/1025/A21/6aA SHEET		
Co	omment: Qty.: 0.8474 sf(s)/Unit Total: 25.4205 sf	(s) B# H	104948	
-	1010/1025/A21/6aA SHEET	(s) B# H) 2	
2.0	WATER JET FLOV	V WATER JET		
	1764114 1164 114111 18411 1181			
Co	omment: FLOW WATER JET			
	1-Cut as per Dwg D2577 (D2577-101 detail)			(Δ)
	Dwg Rev: E		()	
	Prog Rev:	17		
	2-Deburr if necessary AD 2-10-12-6	07-07-2)	
3.0	QC2 INSP	ECT PARTS AS THEY COME OF	FMACHINE	
	12	07-07 -22		
Co	omment: INSPECT PARTS AS THEY COME OFF MACHI			
4.0	QC8 SECC	DND CHECK		
				(as whele
				Kantel
Co	omment: SECOND CHECK	in o	7/07/23	(1.53)
5.0	BRAKE NC NC B	RAKE		
	1 184 01 814 11811 1884			
Co	omment: NC BRAKE			
	1-Form on brake as per Dwg D2577 using DT815	5 and DT8179		0 0
N'	2-Form joggle as per Dwg D2577 using DT8157		FF 07-0	00-00
	3-Identify as D2577-1			
	4-Deburr if nesasary			

Page 1

Form: mrocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									1			
							(1)	-			z	
				2								4
Part No		<u> </u>	PAR #:	Fault Cat			· Au	OD - V	∕Ñà DQA		\ D.4. 6	7/08/28

					/C Closed:	Date: _	
NCR:		W)				
		Description of NC		Corrective Action Section B	Verification	Approval	
DATE	TE STEP Description of NC Section A	Initial Chief Eng	Action Description Sign & Date	Section C	Approval Chief Eng	Approva QC Inspecto	
					a ^t		
			•				
		4					
-				19			
						·	

NOTE: Date & initial all entries

	ursday, 6/21/2 n Johnston	2007 2:29:09 PM			
User, Kill	1 3011151011		Process Sheet		
Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: WEARPLATE	
•	2		•		
Job Number	: 33055		Part Number	: D25771	
Job Number:					
Seq. #:	Machine	or Operation:	Do	scription :	
		or Operation:	INSPECT WORK TO CURREN		
6.0	QC5		INSPECT WORK TO CORRE		
					counter
Comm	nent: INSPEC	T WORK TO CURRENT S	TEP P P	08/03	(872)
7.0	LARGE FAB		LARGE FABRICATION RESO		
į.					
Comm	ent: LARGE	FABRICATION RESOURC	E 1		
	Weld ha	rd surface using DT8308A	& DT8308B as per Dwg D2577		
	Qty	Description	Batch		whoole for
		7560 Hardcoat Rod	M 104721 /M	105138 FC 0	1/08/23 (30)
8.0	QC9	TALLETTE THE THE	VISUAL WELDING INSPECTION	NC	, – I
			• cir		
0		IIII IIII IIII IIII			(0.5) (0.5)
		WELDING INSPECTION	' POWDER CONTINO	1207/	08/27 (30)
9.0	POWDER CO	OATING HINNIHIIIIIIII	POWDER COATING	1 (441) (810 81 (101) (611) (641	(724)
			1104 84		(30%)
Comm	nent: POWDE	ER COATING	10.101		110
55		Coat Grey Sandtex (Ref: 4.	3.5.6) as per QSI 005 4.3	Mil O	7/08/28
10.0	QC3	Total orby barratox (1 tol.) II	INSPECT POWDER COAT/CH	HEMICAL CONVERSION	1/ - 0/ 0 -
					1/
Comm	ent: INSPEC	T POWDER COAT/CHEMI	CAL CONVERSION	Fyl C	11/08/28
11.0	PACKAGING	61	PACKAGING RESOURCE #1		1 7
Comm		SING RESOURCE #1	willing the	W. Carry	
	•	and Stock	Sell Free	FI A	7/08/25 (30)
12.0	Location QC21	11 13	FINAL INSPECTION/W/O REL		700/20
12.0	QC21		FINAL INSPECTION/W/O REL	EASE	
					(3g)
Comm	ent: FINAL IN	NSPECTION/W/O RELEAS	 F		86188
				<u> </u>	N100100
Job Completion					,/
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Page 2

Dart Aerospace	Ltd
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W/O:			ORDER CHA	ANGES						
DATE	STEP	PROC	EDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								·		
		2								
Part No		 PAR #:	_ Fault Category:		NO	R: Yes	No DQ		Date:	

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
		Descrin	tion of NC		Corrective Action	Section B	- ·	Verification		Ammayal			
DATE	STEP	Sec.	Description of NC Section A		. Action Descr Chief Eng	iption	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33055
Description: Wearshoe	Part Number:	D2577-1
Inspection Dwg: D2577 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

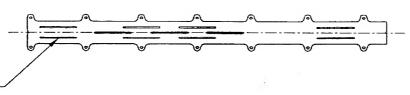
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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+/-0.010					
+/-0.010					
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+/-0.010		,			
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Measured by:	Audited by:	Sr	Prototype Approval:	N/A
Date: 67-07-33	Date:	4/07/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.06.14	New Issue	KJ/JLM 🛠	E

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308-



<u>D2577-1 & D2577-3 WEARSHOE</u>

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

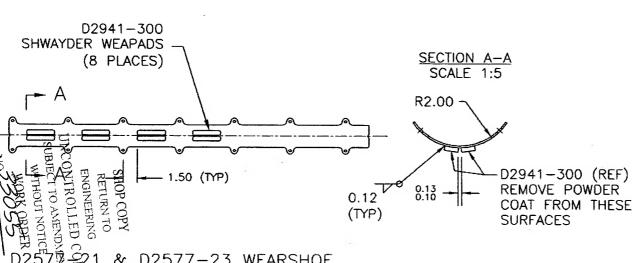
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED









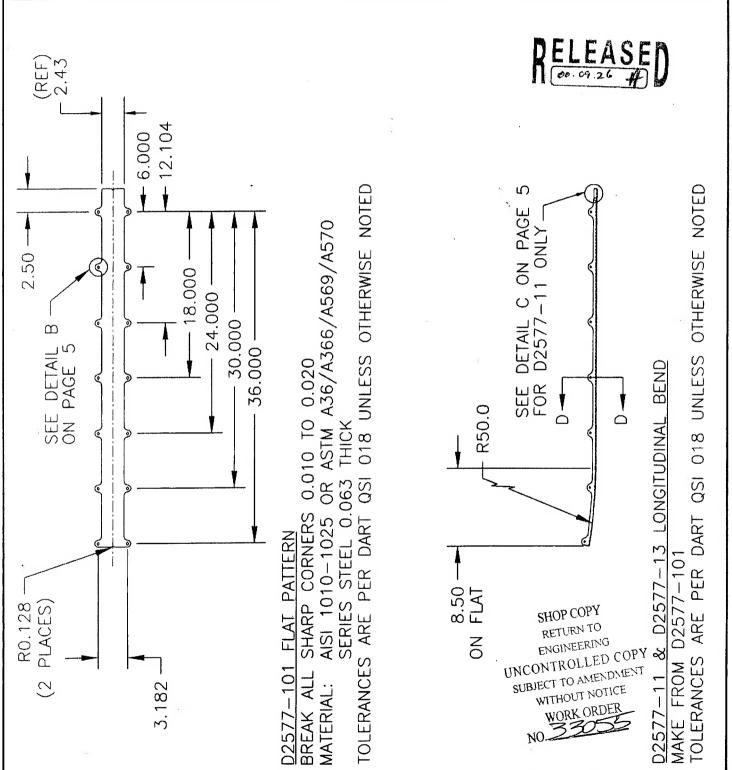
1257₹-\$21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
	4	D2577	SHEET 2 OF 5
DATE		TITLE	SCALE
00.09.22		WEARSHOE	1:10



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SIHI DOCUMENT D2577-5 FLAT PATTERN 2.50 Ø SEE DETAIL ON PAGE 5 2.50 (REF) Copyright ©
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OR COMMUNICATED TO ANY OTHER PERS 2.43 (REF) 3.182 38.500 7 EQUAL SPACE 5.500 PITCH (REF) R0.129 NOTCH (2 PLACES) 00.09.22 43.50 1996 by DART AEROSPACE ON THE EXPRESS CONDITION THAT IT IS SON WITHOUT WRITTEN PERMISSION FROM D2577-5 LONGITUDINAL BEND SEE DETAIL C ON PAGE 5 DRAWING N D2577 UNCONTROLLED COPY WEARSHOE SUBJECT TO AMENDMENT SHOP COPY WITHOUT NOTICE ENGINEERING RETURN TO DART A) BE USED FOR ANY PURPOSE AEROSPACE LTD. D2577-5 WEARSHOE BREAK ALL SHARP CORNERS 0.010 TO 0.020 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 SERIES STEEL 0.063 THICK SHEET 유 POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 3 OF 5 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED REV.

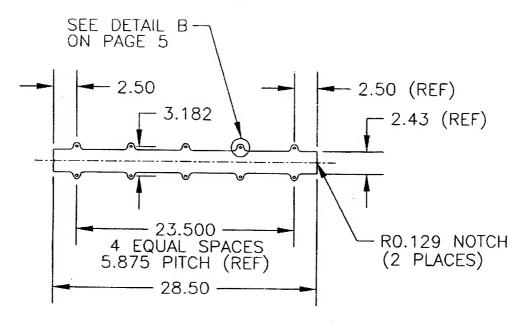
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PURPOSE

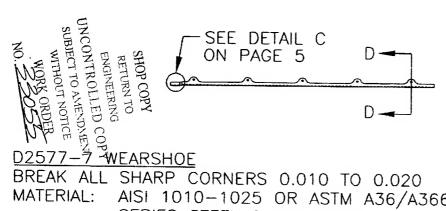
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D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



SHARP CORNERS 0.010 TO 0.020

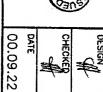
AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3 FINISH: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED







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31		TITLE

WEARSHOE

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SHEET

4 OF REV.

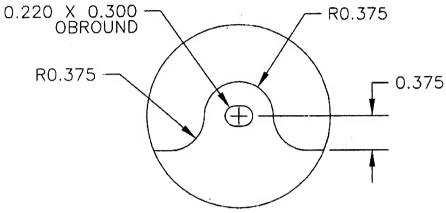




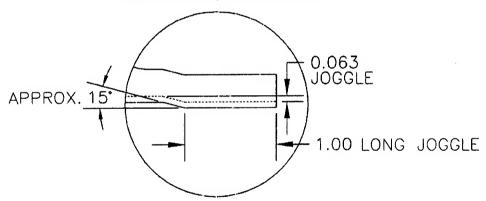
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#	1 #	D2577	SHEET 5 OF 5
DATE		TITLE	SCALE
00.09.22		WEARSHOE	1:10

DETAIL B (SCALE 1:1)

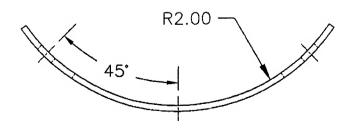




DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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